

Date: Friday, 22/05/2009 8:58:23 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : ANGLE
<b>Job Number</b> : 48105	
<b>Estimate Number</b> : 12048	
<b>P.O. Number</b> :	<b>Part Number</b> : D20654711
<b>This Issue</b> : 22/05/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D206-547 REV F
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL / MED FAB	<b>Drawing Revision</b> : F
<b>Previous Run</b> : 47287	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 28/05/2009 <b>Qty:</b> 12 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 09.05.25</u>	
<b>Comment</b> : Est Rev:D 04-11-17 Reformat JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6063T5A0750W063	Angle6063T5 .750 X.750 X.063w



**Comment:** Qty.: 1.0000 f(s)/Unit Total : 12.0000 f(s)  
 Material: 6063-T5 (QQ-A-200/9) 0.063" wall  
 M6063T5A750W063)  
 Identify as D206-547-11  
 Batch: 1112040

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Cut parts to 12.00" length from 0.063" x 0.75" angle

2-Deburr

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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**Comment:** INSPECT POWDER COAT/CHEMICAL CONVERSION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 22/05/2009 8:58:24 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 48105

Part Number: D20654711

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



(12x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 182

9/6/16

sp

7.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/16

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 09-06-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <b>BW</b>	DRAWN BY <b>RF</b>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>CP</b>	APPROVED <b>KE</b>	DRAWING NO. D206-547	REV. F SHEET 1 OF 5
DATE 99.02.11		TITLE CONSOLE ASSEMBLY	SCALE NTS
-	82.11.23	NEW ISSUE	
A	83.01.18	REDRAWN, ADD NOTE 4	
B	84.10.23	D206-547 WAS 01.B.81.017	
C	89.03.30	REDRAWN	
D	90.12.06	COMPANY NAME CHANGE MS20470 WAS MS20426 DIM 1.312 WAS 1.0, 13.160 WAS 12.85	
E	97.10.22	REDRAWN, ADD -043,-045,-047	
F	99.02.11	ADD MS20470AD3-3 RIVET (NC 143) UPDATED WELD DETAIL	

RELEASED  
99.03.05 RE

-041	-043	-045	-047	PART NUMBER	DESCRIPTION
X				D206-547-041	CONSOLE ASSEMBLY
	X			D206-547-043	CONSOLE ASSEMBLY
		X		D407-547-045	CONSOLE ASSEMBLY
			X	D407-547-047	CONSOLE ASSEMBLY
1				D2601-1	CONSOLE SIDE
1				D2601-2	CONSOLE SIDE
	1			D2602-1	CONSOLE SIDE
	1			D2602-2	CONSOLE SIDE
		1		D2603-1	CONSOLE SIDE
		1		D2603-2	CONSOLE SIDE
			1	D2604-1	CONSOLE SIDE
			1	D2604-2	CONSOLE SIDE
1		1		D2605	CONSOLE BRACKET
	1		1	D2606	CONSOLE BRACKET
1	1			D2607	CONSOLE BRACKET
		1	1	D2608	CONSOLE BRACKET
1		1		D2709-1	CONSOLE SIDE RAIL
1		1		D2709-2	CONSOLE SIDE RAIL
1		1		D2709-3	CONSOLE SIDE RAIL
1		1		D2709-4	CONSOLE SIDE RAIL
	1		1	D2710-1	CONSOLE SIDE RAIL
	1		1	D2710-2	CONSOLE SIDE RAIL
	1		1	D2710-3	CONSOLE SIDE RAIL
	1		1	D2710-4	CONSOLE SIDE RAIL
10	8	8	6	MS20470AD3-3	RIVET
18	20	18	20	MS20470AD3-4	RIVET

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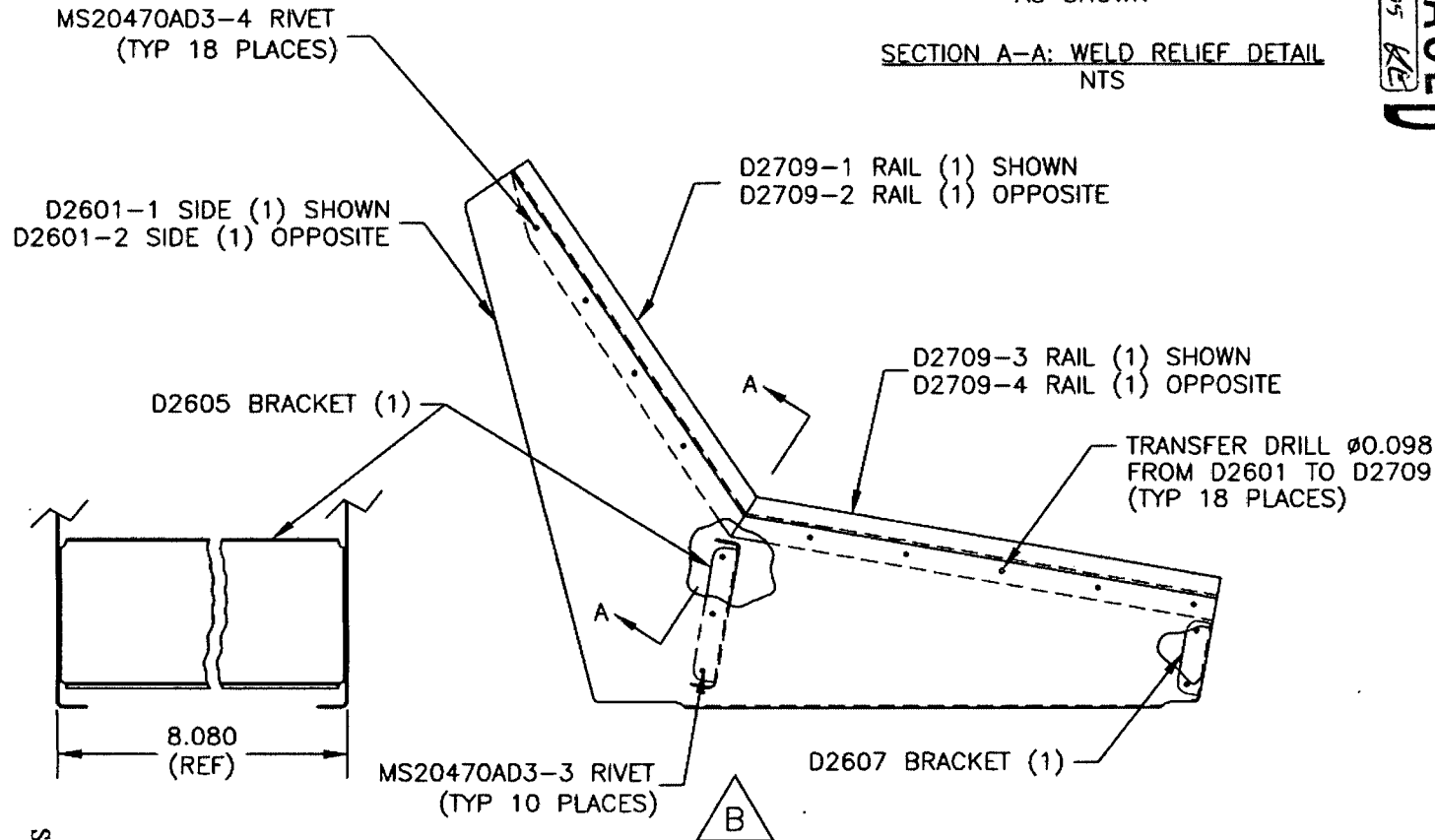
**DART**

RELEASED  
910305 KE



GRIND RELIEF  
CHAMFER FOR WELD  
0.040-0.050 x 45°  
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL  
NTS



D206-547-041 (206 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JP	APPROVED KE	DRAWING NO. D206-547	REV. F SHEET 2 OF 5
DATE 99.02.11	TITLE CONSOLE ASSEMBLY	SCALE 1:4	

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**DART**

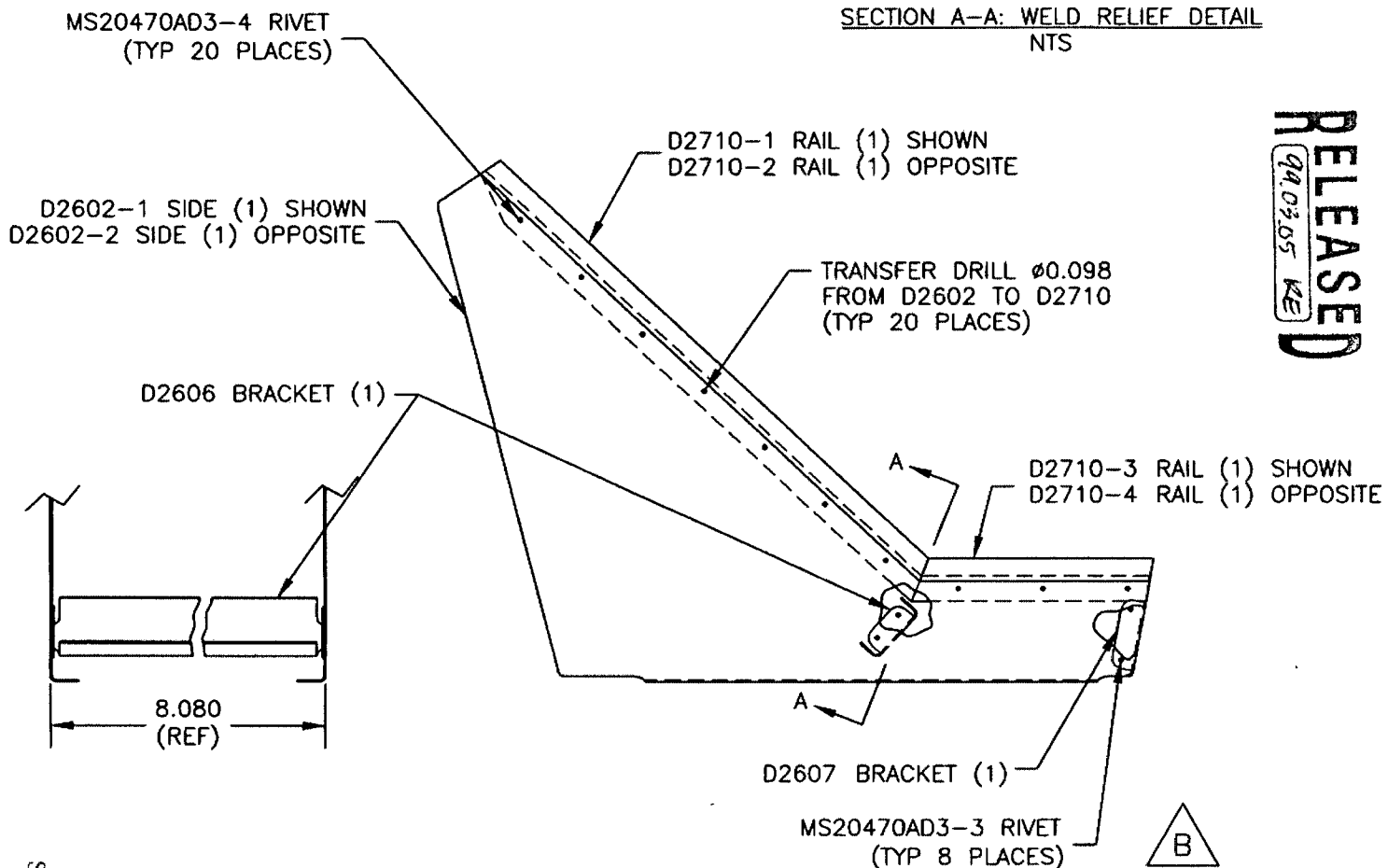
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CHECKED	JP	APPROVED	KE	DRAWING NO. D206-547
DATE	99.02.11	TITLE	CONSOLE ASSEMBLY	REV. F SHEET 3 OF 5
		SCALE	1:4	

RELEASED  
99.03.05 KE



GRIND RELIEF  
CHAMFER FOR WELD  
0.040-0.050 x 45°  
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL  
NTS



D206-547-043 (206 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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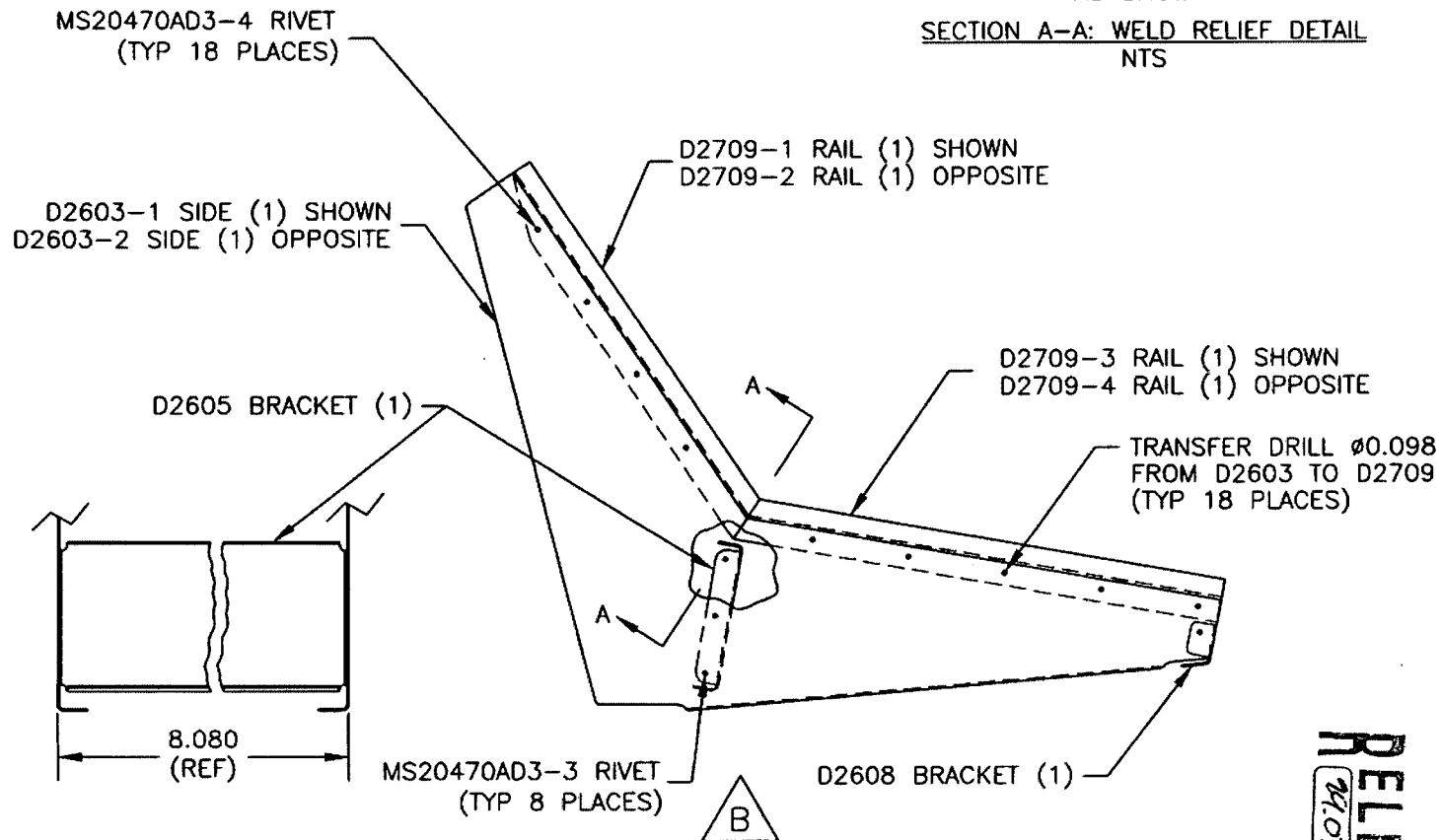
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**DART**



GRIND RELIEF  
CHAMFER FOR WELD  
0.040-0.050 x 45°  
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL  
NTS



D407-547-045 (407 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**RELEASED**  
24.03.05 KE

DESIGN <b>BW</b>	DRAWN BY <b>RF</b>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-547	REV. F SHEET 4 OF 5
DATE 99.02.11	TITLE CONSOLE ASSEMBLY	SCALE 1:4	

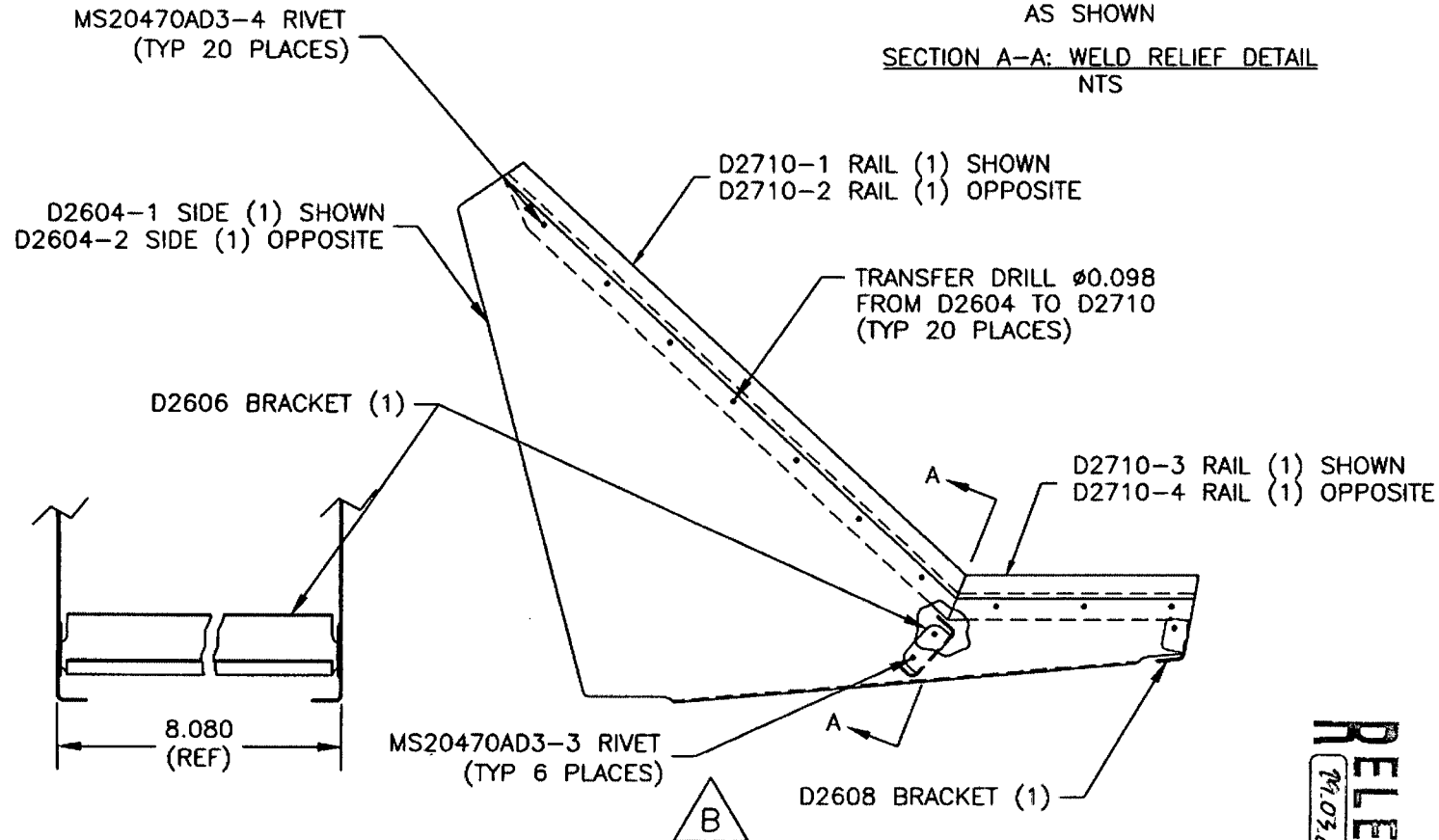


**DART**



GRIND RELIEF  
CHAMFER FOR WELD  
0.040-0.050 x 45°  
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL  
NTS



D407-547-047 (407 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**RELEASED**  
11/03/05 KE

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CHECKED UP	APPROVED KE	DRAWING NO. D206-547
DATE 99.02.11	TITLE CONSOLE ASSEMBLY	REV. F SHEET 5 OF 5
	SCALE 1:4	